

**ABSTRACT OF THE DISCLOSURE**

There are provided methods and compositions for co-fired multilayer piezoelectric ceramic materials with base metal electrodes. The method of the invention is performed at low firing temperatures and without the oxidation of base metal or reduction of ceramic components. A variety of ceramic materials may be used and copper is the preferred base metal in the multi-layer piezoelectric devices of the invention.

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0993294-11601  
T09T1-492660